

ABSTRACT OF THE DISCLOSURE

A computer controlled laser machine tool is provided wherein the machine tool work zone is smaller than the size of the workpiece that can be processed. The machine tool has an apparatus to register the workhead guidance system to the workpiece without requiring a hole in the workpiece. The machine tool is adapted with an image sensor, a form of a digital camera, to measure the position of targets etched in or affixed to the surface of the workpiece. Registration of the workhead guidance system relative to the workpiece is checked before and after the workpiece support is indexed.